

SPLIT - 2

Work Order ID 117027 - 2

117027

Page 1

June-09-14 2:31:23 PM

Item ID: D4095-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 4/23/14 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								

105

0.00

1105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 24577
 CUT PER DRWG D4095 REV.B

CL 14/06/12 12

115

Receive & Inspect for Damage & Mat'l Certs

0.00

1115

Packaging

Memo

0.00

Packaging

Pc 14/7/14 (12)

125

QC6- Inspect dimensions to drawing

0.00

1125

QC

Memo

0.00

Quality Control

14/7/14

10

Page 2

Memo

Work Order ID 117027

117027

Page 3

June-09-14 2:31:23 PM

Item ID: D4095-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 4/23/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/23/14

Req'd Qty: 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop *NR2*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QS1004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

6 CPE 14.11.19

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

6 CPC 14.11.19

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 130617DAS
41
9-89

6

14-11-20

Work Order ID 117027

June-09-14 2:31:23 PM

117027

Page 4

Item ID: D4095-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 4/23/14 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC3- Inspect Part Finish	0.00							
190						6			DAS 38 9-89
QC	Memo	0.00							
Quality Control									

NOV 21 2014

200	Identify as per dwg & Stock Location: <u>FP-007</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

AP 4-11-21

Picklist Print

June-09-14 2:31:22 PM

Page 1

Work Order ID: 117027

117027

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	144.8670	2.275	29			

M304S16GA

**

C 2/4/06/19

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

144.867

M127821

75.567

M128423

1.2

M129192

68.1

m129545

DART AEROSPACE LTD		Work Order:	117027
Description: Wearplate		Part Number:	D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1	

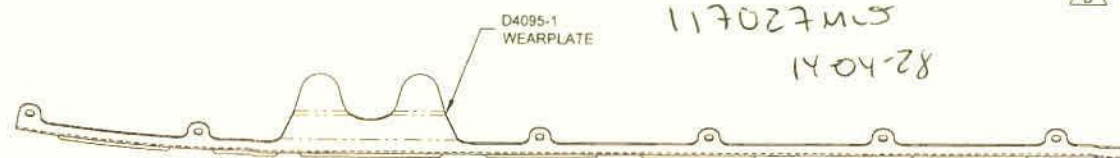
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190"	-		✓	Jkm01
0.300	+/-0.010	0.295"	-		✓	
0.300	+/-0.010	0.294"	-		✓	
2.432	+/-0.010	2.432"	-		✓	
3.227	+/-0.010	3.227"	-		✓	
4.06	+/-0.030	4.06"	-		✓	
2.50	+/-0.030	2.50"	-		✓	
4.98	+/-0.030	4.98"	-		✓	
8.43	+/-0.030	8.43"	-		✓	Jkm00
11.50	+/-0.030	11.50"	-		T	Jkm03
21.750	+/-0.010	21.750"	-		T	
3.500	+/-0.010	3.500"	-		✓	
12.22	+/-0.030	12.73"	-		T	
6.000	+/-0.010	6.003"	-		✓	
12.100	+/-0.010	12.100"	-		T	
21.00	+/-0.030	21.00"	-		T	
30.000	+/-0.010	30.000"	-		T	
36.000	+/-0.010	36.000"	-		T	
38.88	+/-0.030	38.88"	-		T	
0.063	+/-0.010	0.058"	-		✓	

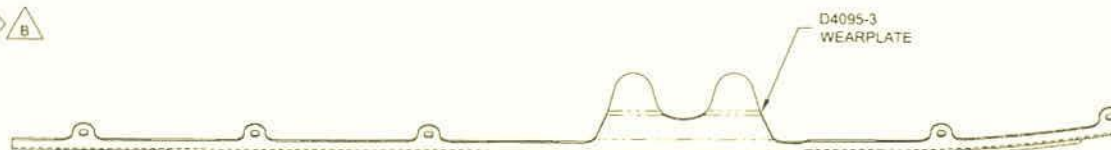
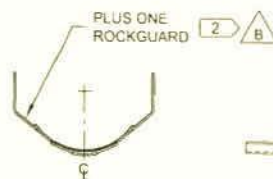
Measured by:	DAS 23 9-89	Audited by:	DAS 27 9-89	Preliminary Approval:	
Date:	14-07-7	Date:	14/7/7	Date:	

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

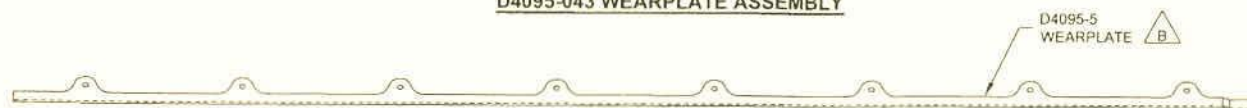
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8	1						D4095-3	WEARPLATE
9		1					D4095-5	WEARPLATE
10			1				D4095-7	WEARPAD
11				1			D4095-9	WEARPAD
12					1		D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



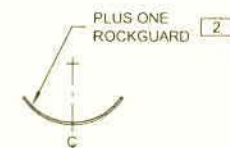
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



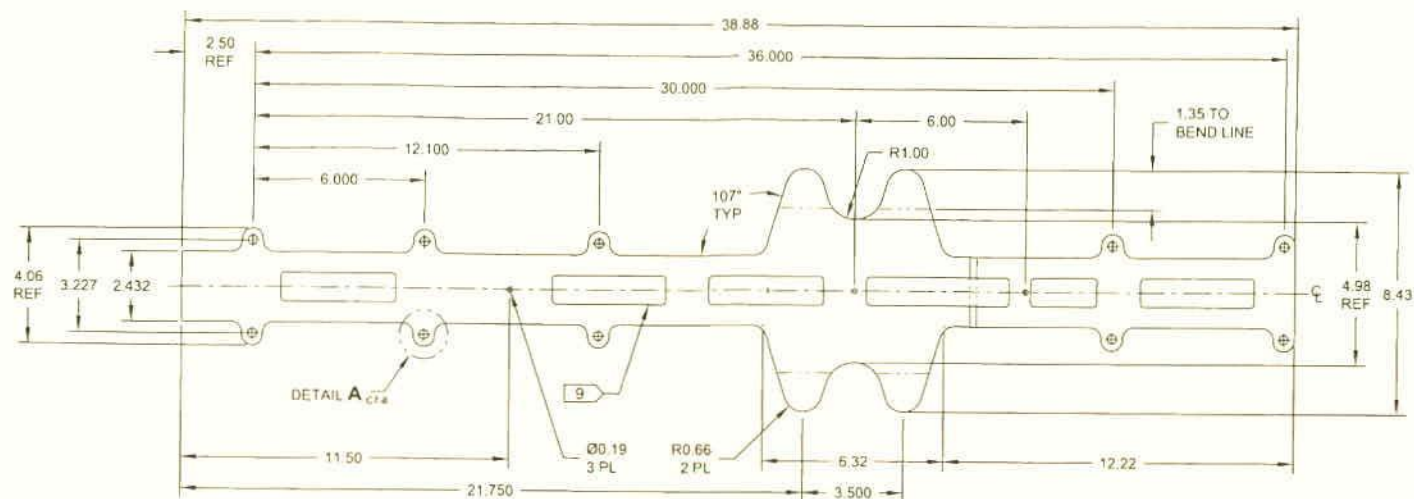
D4095-045 WEARPLATE ASSEMBLY



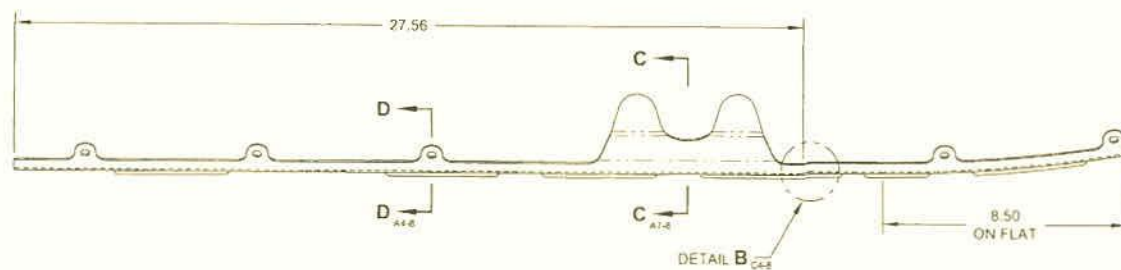
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI D18 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F: 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3, ADDED D4095-5/-7/-9/-11, REVISED HARDCOAT DESIGN. REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	1/10	DRAWING NO.	REV. B
MFG. APPR.	1/10	D4095	SHEET 1 OF 8
APPROVED	1/10	TITLE	SCALE
DE APPR	1/10	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



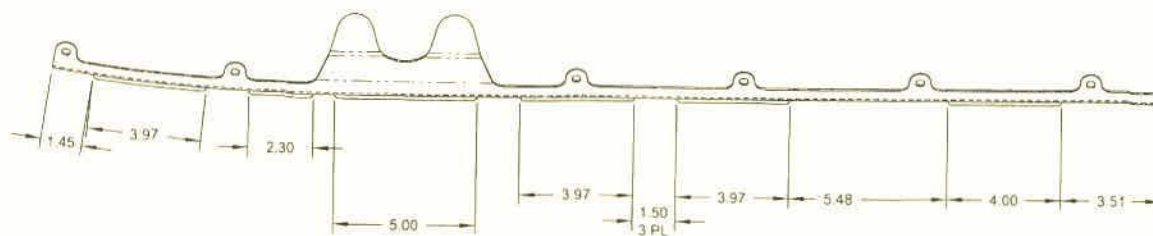
D4095-3F FLAT PATTERN 1



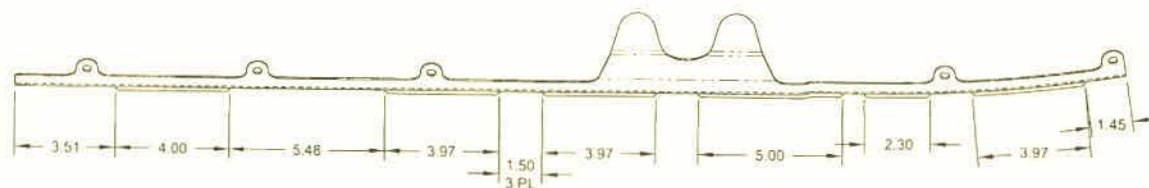
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

RELEASE
2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG APPR.	140	D4095	SHEET 4 OF 8
APPROVED	140	TITLE	SCALE
DE APPR	140	WEARPLATE	NTS
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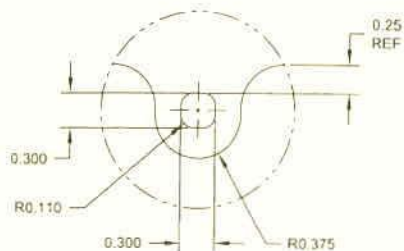
D4095-1 WELDING DETAIL B



D4095-3 WELDING DETAIL B

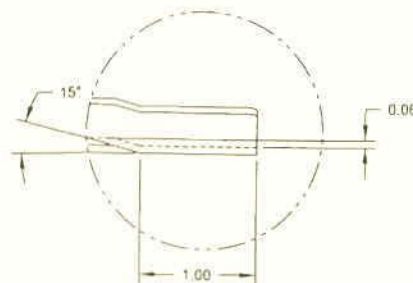
RELEASED
2011-10-31
M

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AP</i>	D4095	SHEET 5 OF 8
APPROVED	<i>AP</i>	TITLE	SCALE
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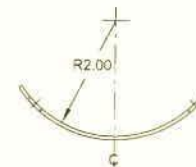
DETAIL A: TAB DETAIL

SCALE 4X
C3-3
C6-4
D3-8
D2-7



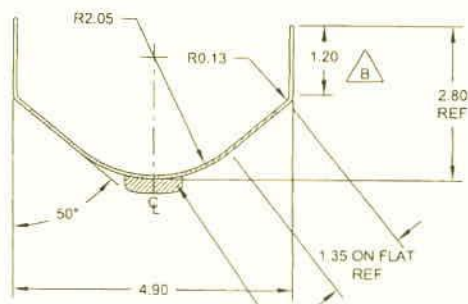
DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-3
B6-3
B3-4
B2-4



SECTION E-E

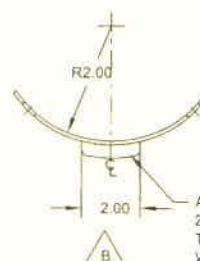
SCALE 2X
B5-4
B2-7



SECTION C-C

SCALE 2X
B5-3
B6-4

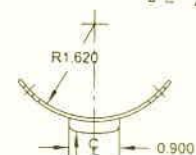
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION D-D

SCALE 2X
B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X
B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31
NIP

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG APPR.	<i>[Signature]</i>	D4095	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	WEARPLATE	NTS
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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6177
Date: 2014-07-02
Page: 1

Sold to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Ship to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24577	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-02
Tracking No.:	

Item No.	Unit	Description	Quantity
d3564-5	Chaque	d3564-5	24
d3564-9	Chaque	d3564-9	24
d3564-11	Chaque	d3564-11	24
d3791-1	Chaque	d3791-1 wearpad	24
d3537-3	Chaque	d3537-3 wearpad	40
d3537-1	Chaque	d3537-1 wearpad	60
d3537-1	Chaque	d3537-1 wearpad	60
d3791-1	Chaque	d3791-1 wearpad	20
d2154	Chaque	d2154 bracket stud	40
d2144	Chaque	d2144 hinge doubler	40
d4095-045	Chaque	d4095-045 wearplate assy	12
d4095-043	Chaque	d4095-043	12
d4095-041	Chaque	d4095-041 wearplate assy	12
d3859-041	Chaque	d3859-041 wearplate	16
d4952-1	Chaque	d4952-1 wearplate	20
d4095-051	Chaque	d4095-051 wearplate assy	20
d4095-049	Chaque	d4095-049 wearpad	16
d4095-047	Chaque	d4095-047 wearplate assy	20
d4798-041	Chaque	d4798-041 wearplate assy	16
d4135-1	Chaque	d4135-1 wearpad	10
d4360-041	Chaque	d4360-041 wearplate assy	8
d2012-111	Chaque	d2012-111 bracket	40
d2324-5	Chaque	d2324-5 strap	40
d2947	Chaque	d2947 clamp	60
d3171-1	Chaque	d3171-1 angle bracket	20
d3463-3	Chaque	d3463-3 step	12
d3512-1	Chaque	d3512-1 wearplate	16
d3629-1	Chaque	d3629-1 bracket	20
d3955-5	Chaque	d3955-5 plate	12
d4021-5	Chaque	d4021-5 blanking plate	40
d3556-1	Chaque	d3556-1 clamp	40

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days